

#62308

RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	B67-43001-07	SHEET 3 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
DATE	10.05.04	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

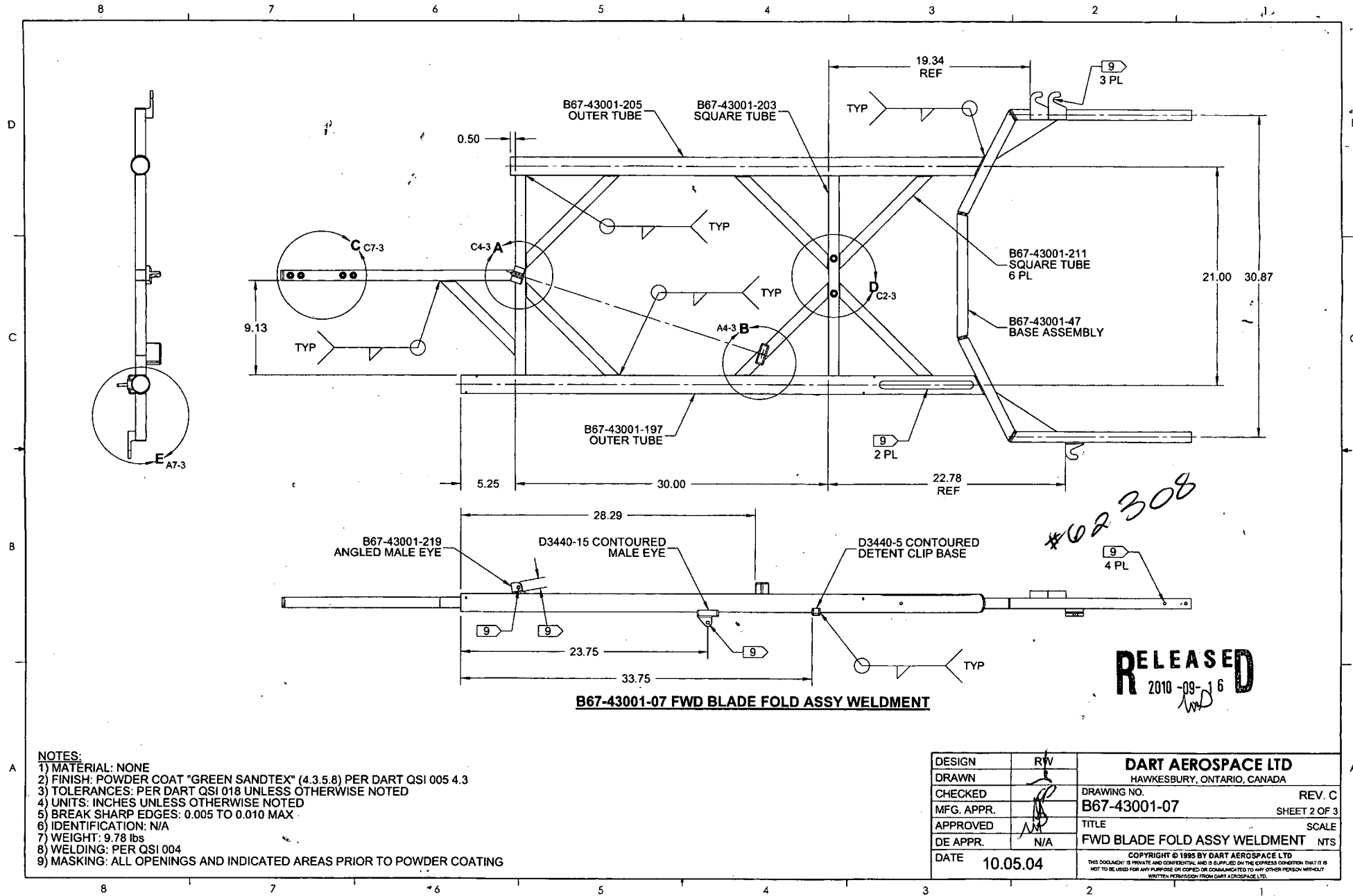
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

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APPROVED		TITLE	SCALE
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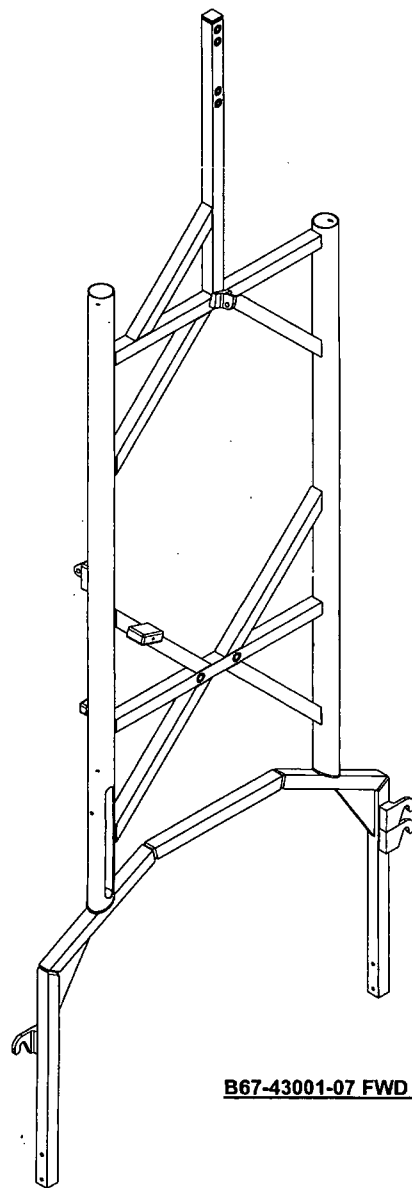
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B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

ITEM	QTY -07	P/N	DESCRIPTION
1	X	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-197	OUTER TUBE
4	2	B67-43001-199	OUTER TUBE END CAP
5	1	B67-43001-201	SQUARE TUBE
6	1	B67-43001-203	SQUARE TUBE
7	1	B67-43001-205	OUTER TUBE
8	1	B67-43001-207	SQUARE TUBE
9	1	B67-43001-209	SQUARE TUBE
10	6	B67-43001-211	SQUARE TUBE
11	1	B67-43001-219	ANGLED MALE EYE
12	1	B67-43001-223	SQUARE CAP
13	4	B67-43001-225	BUSHING
14	2	B67-43001-227	BUSHING
15	1	D3440-5	CONTOURED DETENT CLIP BASE
16	1	D3440-7	DETENT CLIP BASE
17	1	D3440-15	CONTOURED MALE EYE

62308

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2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 5 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	B67-43001-07	SHEET 1 OF 3
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	FWD BLADE FOLD ASSY WELDMENT	NTS
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Picklist Print

Friday, September 24, 2010 3:46:17 PM

Page 4

Work Order ID: 62308

Parent Item: PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3440-15

Manufactured No

100

Each

1.0000

1

1



Contoured Male Eye (Supersedes B67-43001-215)

10.09.27

Location

Loc Qty

Loc Code

ST441

1

41453

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-223



Square Cap

Manufactured

No

100

Each

44.0000

1

1

Location

Loc Qty

Loc Code

ST438

44

47504

44

PB67-43001-225



Bushing

Manufactured

No

100

Each

29.0000

4

4

Location

Loc Qty

Loc Code

ST438

29

44988

29

PB67-43001-227



Bushing

Manufactured

No

100

Each

54.0000

2

2

Location

Loc Qty

Loc Code

ST438

54

43712

22

44987

32

D3440-7



Detent Clip Base (Supersedes B67-43001-221)

Manufactured

No

100

Each

2.0000

1

1

Location

Loc Qty

Loc Code

ST441

2

41455

2

D3440-5



Contoured Detent Clip Base (Supersedes B67-43001-217)

Manufactured

No

100

Each

2.0000

1

1

Location

Loc Qty

Loc Code

ST441

2

41454

2

Friday, September 24, 2010 3:46:17 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 62308

Parent Item: PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-205

Manufactured

No

100

Each

1.0000

1

1



Outer Tube



10.09.27



Location

Loc Qty

Loc Code

ST446

352603

1

45259

1

PB67-43001-207

Manufactured

No

100

Each

2.0000

1

1



Square Tube



10.09.27

Location

Loc Qty

Loc Code

ST437

2

52604

2

PB67-43001-209

Manufactured

No

100

Each

4.0000

1

1



Square Tube



10.09.27

Location

Loc Qty

Loc Code

ST437

4

52485

4

PB67-43001-211

Manufactured

No

100

Each

12.0000

6

6



Square Tube



10.09.27

Location

Loc Qty

Loc Code

ST437

12

52486

12

PB67-43001-219

Manufactured

No

100

Each

8.0000

1

1



Angled Male Eye



10.09.27

Location

Loc Qty

Loc Code

ST438

8

52606

8

Friday, September 24, 2010 3:46:17 PM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 1

Work Order ID: 62308

Parent Item: PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec
10.09.24 per revC dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-47		Manufactured	No			100	Each	0.0000	1	1			
---------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Base Assembly

PB67-43001-197		Manufactured	No			100	Each	1.0000	1	1			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Outer Tube

Location

Loc Qty

Loc Code

ST446

1

41483

1

PB67-43001-199		Manufactured	No			100	Each	21.0000	2	2			
----------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Outer Tube End Cap

Location

Loc Qty

Loc Code

ST446B

21

44991

21

PB67-43001-201		Manufactured	No			100	Each	0.0000	1	1			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Square Tube

PB67-43001-203		Manufactured	No			100	Each	1.0000	1	1			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Square Tube

Location

Loc Qty

Loc Code

ST437

1

41907

1

362412

10.09.30

10.09.27

1
2

10.09.27

10.09.27

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 62308

Friday, September 24, 2010 3:46:17 PM



Page 3

Item ID: PB67-43001-07

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 9/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18 *[Signature]*
MF
10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 62308

Friday, September 24, 2010 3:46:17 PM



Page 2

Item ID: PB67-43001-07

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 9/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

10-10-6

M18144

Memo

0.00

***mask inside of D3440-5, D3440-7 and D3440-15 prior to
paint***☐START TIME: *3:50* ☐OVEN
TEMPERATURE: *320°* ☐FINISH TIME: *4:20*

①

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

7/10/10/08

Memo

0.00

1 0

150



Packaging

Packaging

Identify as per dwg & Stock Location: *WA*

0.00

10-10-14

Memo

0.00

1 0

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Friday, September 24, 2010 3:46:17 PM



Page 1

Item ID: PB67-43001-07

Accept



Setup Start



Revision ID:

Item Name: Fwd Blade Fold Assembly Weldment

Stop



Start Date: 9/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mt* Date: *10-9-24* Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-07	Rev C								

100 Large Fab 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001 *** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***

10-09-01

1

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

Memo

0.00

10.10.05

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo

0.00

8/10/06

XC